

5/20

DART AEROSPACE LTD

Work Order:

23022

Description: Wheel Shaft

Part Number:

D3334-1

Dwg: D3334 Rev. A

Qty:

24 20 17

Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	RJ	05.04.13	2420
2	MS	Cut blanks: Ø3.500" Bar to 7.750" long Material: AISI 4140 or ASTM A304-02/A-434-BC/A193-03-Grade-B7/A29-03/A322-91 or UNS# G41400 (M4140H-R3.500) Identify for D3334-1	ML	05/06/16	20
3	MS	Turn as per Folio FA492 and Dwg D3334	ML	05/06/16	20
4	QC2	Inspect parts as they come off the CNC machine	ML	05/06/16	20
5	MS	Deburr	ML	05/06/16	20
6	MV	Machine as per Folio FA492 and Dwg D3334 Identify as D3334-1	SD	05.06.16	17
7	QC2	Inspect parts as they come off the CNC machine	SD	05.06.16	17
8	QC8	Second check	EP	05.06.16	17
9	QC5	Inspect work to step 8	CO	05.06.16	17
10	FP	Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3 Mask thread and bearing surface	FC	05.06.27	17
11	QC3	Inspect Powder Coat	ML	05.06.28	17
12	ST	Identify and Stock	CL	05/06/28	17
13	AC	Cost / part: 64.10	R	05/06/29	17
14	DC	Close W/O 64.88 Inspect Level 21	RJ	05/07/05	17

Rev	Date	Change	Revised By	Approved
A	05.01.13	New issue	KJ/JLM	
B	05.03.02	Revised material; Added Powder Coat	KJ/JLM	

RELEASED

05/25/03-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR: 23022		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-06-24	6	2x D3334-1 turned in chuck w/sc damaging the sides of wheel shafts 1x D3334-1 A bit burned and melted into one of four holes.		Scrap and destroy replace on split w/o 23022 C	 05-06-24	 05-06-24	 05-06-24	 05-06-24

Part No: D3334-1 PAR #: \_\_\_\_\_ Fault Category: Prod / machine parts NCR: Yes No DQA:  Date: 05/07/05

NOTE: Date & initial all entries QA: N/C Closed:  Date: 05.07.05





1) MATERIAL: AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03-GRADE-B7/ A29-03/ A322-91  
OR UNS#-G41400 (REF. DART SPEC. M4140H-R3.500)

2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) ALL DIMENSIONS ARE IN INCHES

5) BREAK ALL SHARP EDGES 0.010 TO 0.020

WORK ORD 736

SHOP COPY  
RETURN TO  
ENGINEERING  
FILED COPY  
A29-037 A322-91  
THROTT NOTICE  
WORK ORDER  
NO. 23022

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART AEROSPACE LTD		Work Order: 23022
Description: Wheel Shaft		Part Number: D3334-1
Inspection Dwg: D3334 Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
7.468	±.010	7.468	✓			
0.750	±.010	.745	✓			
1.04	±.030	1.036	✓			
4.740	±.006 ±.030	4.732	✓			
0.94	±.030	0.942	✓			
0.200	±.010	.198	✓			
Ø1.750	±.010	Ø1.750	✓			
R0.063	±.010	R0.063	✓			
3.060	±.010	3.062	✓			
Ø0.386	±.005 ±.000	Ø.386	✓			
2.250	±.005	2.251	✓			
Ø3.470	±.016	Ø3.471	✓			
1.300	±.005	1.302	✓			
R0.125	±.010	R0.125	✓			
Ø0.129	±.005 ±.000	.129	✓			

Measured by: <i>my/SD</i>	Audited by: <i>Er</i>	Prototype Approval: <i>N/A</i>
Date: 05/06/17	Date: 05/06/17	Date: <i>N/A</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	